



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5621-041
Job Sheet 198077



Part No: D5621-041

Job Qty: 1 pcs

Part Name: Skylight Window Assembly, LH Clear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/19

Job Tracking No:

Created By: Chantal Lavoie

Due Date: 8/21/19

Description:

Note: D5621 REV.C IPP REV:A 18.05.22 NEW ISSUE DD VERF:JFS IPP REV:B 18.09.04 AS PER DWG REV.B DD VERF:JFS IPP REV:C 19.01.14 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	1 pcs	8/21/19	8/21/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	1 pcs	8/21/19	8/21/19	0.00	1.00	Packaging 2 - 1 - B4B	SEP 10 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	SEP 10 2019
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	



Container No: S212560

Part: D5621 - 041

Job No: 198077

Serial No/Batch: S212560

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/10/19

					Packaging 2 - 28 - B4B		
					Packaging 2 - 29 - B4B		
					Packaging 2 - 30 - B4B		
					Packaging 2 - 31 - B4B		
					Packaging 2 - 32 - B4B		
					Packaging 2 - 33 - B4B		
					Packaging 2 - 34 - B4B		
					Packaging 2 - 35 - B4B		
					Packaging 2 - 36 - B4B		
120	QC 6	1 pcs	8/21/19	0.00 0.00	QC 6 - 9	DAS	
					QC 6 - 68	81	
					QC 6 - 61	9-89	
					QC 6 - 40		SEP 13 2019
					QC 6 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	8/21/19	0.00 1.00	Packaging 3 - 1 - B4B		
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B	px	KG Deck
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
					Packaging 3 - 27 - B4B		
					Packaging 3 - 28 - B4B		
					Packaging 3 - 29 - B4B		
					Packaging 3 - 30 - B4B		
					Packaging 3 - 31 - B4B		
					Packaging 3 - 32 - B4B		
					Packaging 3 - 33 - B4B		
					Packaging 3 - 34 - B4B		
					Packaging 3 - 35 - B4B		
					Packaging 3 - 36 - B4B		
140	QC 21 - SA	1 pcs	8/21/19	0.00 0.00	QC 21 - SA - 21		
					QC 21 - SA - 70		SEP 16 2019
					QC 21 - SA - 53		DAS 70 9-89
					Closed upon 10/1/19		

Part Op 100 - Issue P/O: _____ Supplier: Llamas Manufacture D5621-041 as per Dwg Notes. C of C is required.
 Descriptions: ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOWS***
 110 - (Receive & Inspect for Damage & Mat'l Certs) C of C is required. ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOWS***
 120 - (QC6- All purchased or subcontracted products) ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOWS***
 130 - (Identify as per dwg & Stock Location: _____) ***EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE

SURFACE OF THE WINDOWS***

140 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5621-041P	Skylight Window Assembly, LH Clear	1 Ea (1 ea)	100-Purchasing	5212 498

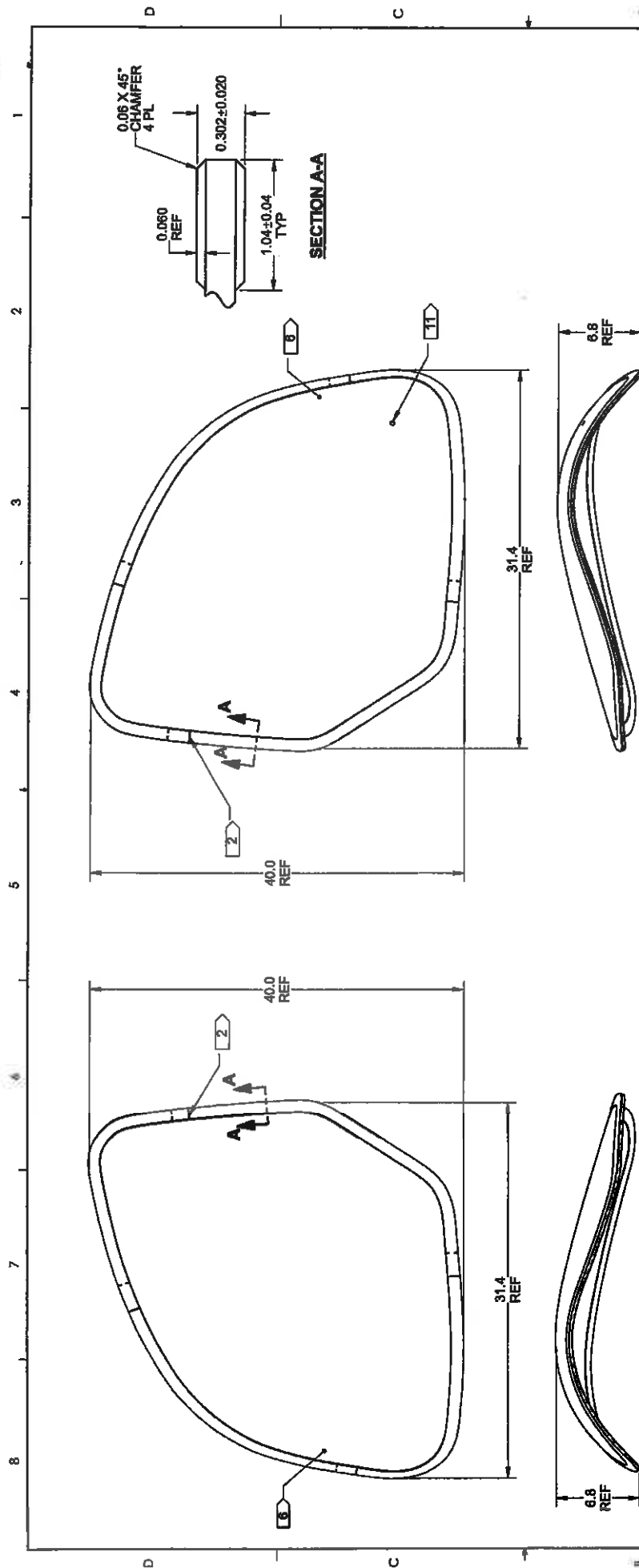
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D5621-041P	1	0	0

Part Specifications

Specifications could not be found.

Plex 7/22/19 11:33 AM Dart.Lavoie.Chantal



D5621-041-043 SKYLIGHT WINDOW, LH

- NOTES:**
- 1) MATERIAL: -041-042: MAKROLON/TUFFAK UC/GP, CLEAR, 0.177" THICK
REF DART SPEC MPOLYS 177-01
-043-044: MAKROLON/TUFFAK CP, BRONZE #5109, 0.187" THICK
REF DART SPEC MPOLYS 187-02
 - 2) FINISH: APPLY LPI AEROCOAT 107P HARDCOAT (BOTH SIDES)
INSTALL LPI 9149 EDGE ATTACHMENT USING PRT425 PER "D5621-041 CF" (LH) OR "D5621-042 CF" (RH)
IT IS ACCEPTABLE TO SPLICE EDGE ATTACHMENT BETWEEN HOLES.
INNER AND OUTER SPLICES MUST BE AT LEAST ONE HOLE SPACING APART
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: ALL TRIMMED SURFACES MUST HAVE FINISH
 - 6) IDENTIFICATION: SANDBLAST IDENTIFICATION USING 0.125" LETTERS IN LOCATION SHOWN (MAX 0.005" DEEP):
D5621-04X (P/N) SN XXX (S/N)
XX-20YY (DATE) 3AL64 (CAGE CODE)
 - 7) WEIGHT: 6.40 - 7.25 LBS
 - 8) FORM PER LPI PROCESS "D5621" USING LPI FORMING TOOL "D5621-041 FM" (LH) OR "D5621-042 FM" (RH) RESPECTIVELY
 - 9) TRIM PER LPI TRIMMING TOOL "D5621-041 TF" (LH) OR "D5621-042 TF" (RH) RESPECTIVELY
 - 10) EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOW
 - 11) DRILL Ø0.375 HOLE ON -042-044 PER LPI TRIMMING TOOL "D5621-042 TF"
 - 12) ACCEPTANCE CRITERIA:
A) MINIMUM THICKNESS AFTER FORMING IS 0.150"
B) CONTOUR: MUST FIT FORMING TOOLS WITH A MAX GAP OF 0.080" AT THE TRIM LINE WHEN
C) DISTORTION: INSPECTOR TO VIEW THRU PART. NO MORE THAN 3X 0.060" DEFECTS IN A CIRCLE WITH A 6.77" RADIUS.
WINDOW MUST BE GENERALLY PARALLEL EXCEPT FOR WITHIN 1" OF THE WINDOW PERIMETER, WHICH IS NON-OPTICAL

D5621-042-044 SKYLIGHT WINDOW, RH

RELEASED
2019 JAN 11
E.O. 14176

REV.	DESCRIPTION	DATE
C	REVISED NOTE 1	VS 19.01.07
B	ADDED 0.005" AROUND PERIMETER FOR INCREASED EDGE DISTANCE WHEN TRANSFER DRILLING	VS 18.07.25
A	NEW ISSUE	VS 18.02.21
DESIGN	DB	VS
DRAWN	VS	VS
CHECKED	RF	VS
MFG. APPR.	RA	VS
APPROVED	VS	VS
DE APPR.	DS	VS
DATE	19.01.07	

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D5621

TITLE SKYLIGHT WINDOW

REV. C

SHEET 1 OF 1

SCALE NTS

DATE 19.01.07

PROPERTY © 2019 BY DART AEROSPACE LTD
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WRITTEN PERMISSION FROM DART AEROSPACE LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044071



Supplier: LLA001-VU
Llamas Plastics Inc.
12970 Bradley Ave.
Sylmar, CA 91342 USA
Phone: 818-362-0371
Fax: 818-362-9780

PO No: POHB044071

PO Date: 7/22/19

Due Date: 9/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Ship To:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	198077	D5621-041P			Skylight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed	-	9/10/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
2	198078	D5621-042P			Skylight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed	-	9/10/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
3	198079	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed	-	9/10/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
4	198080	D5621-041P			Skylight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed	-	9/16/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00



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PURCHASE ORDER

POHB044071



Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
5	198081	D5621-042P			Skylight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed	-	9/16/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
6	198083	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed	-	9/16/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
7	198088	D5621-041P			Skylight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed	-	9/30/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
8	198089	D5621-042P			Skylight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed	-	9/30/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
9	198090	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed	-	9/30/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
10	198174	D5621-041P			Skylight Window Assembly, LH Clear : Fabricate as per dwg D5621-041 REV.C	Firmed	-	10/14/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00
11	198175	D5621-042P			Skylight Window Assembly, RH Clear : Fabricate as per dwg D5621-042 REV.C	Firmed	-	10/14/19	1 Ea	0 Ea	1 Ea	\$2,246.00/Ea	\$2,246.00

Plex 9/9/19 1:25 PM Dart.Lavoie.Chanta



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PURCHASE ORDER

POHB044071



Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
12	198176	D5674-1P			Drill Bit : as per dwg D5674-1 REV.A	Firmed	-	10/14/19	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02

Grand Total: \$17,968.08

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 9/9/19 1:25 PM Dart.Lavoie.Chantal

2

LLAMAS PLASTICS, INC.

12970 Bradley Avenue
Sylmar, CA 91342-3829

818-362-0371 Fax # 818-362-9780

5212482

Packing Slip

Date	Invoice #
8/21/2019	L45184

Bill To

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON, K6A 1K7
CANADA

Ship To

LAVOICE CHANTAL
PHONE: 613-623-5200
EXT. 242
FAX 613-632-1053
CLAVOICE@DARTAERO.COM

P.O. Number

POHB044071

Rep

Via

F.O.B.

CALL FO...

Sylmar, CA

Quantity

Line Item

Description

1 1

P/N: D5621-041P SKYLIGHT WINDOW ASSY LH
REV.C
S/N: 006 ✓

1 3

P/N: D5674-1P 5/16' DRILL BIT

COUNTRY OF ORIGIN: USA
CURRENCY: US DOLLARS \$

RECEIVED

SEP 09 2019

DART AEROSPACE LTD.

Hudson -
PBB 1906002

RECEIVED

SEP 03 2019

DART AEROSPACE LTD.

3923 PARS

09104

CERTIFICATION OF COMPLIANCE ATTACHED



8/21/19



LLAMAS PLASTICS INC.

12970 BRADLEY AVE.
SYLMAR, CA 91342
(818) 362-0371
Fax (818) 362-9780

DATE: 8/21/19

CERTIFICATION OF COMPLIANCE

TO: **Dart Aerospace**

RE: **Contract/Purchase Order No (s): POHB044071**

Line Item #: **1 & 3**

Shipper No(s): **L45184**

Part No(s): **D5621-041P SKYLIGHT WINDOW ASSY LH**
REV.C D5674-1P 5/16' DRILL BIT

Quantity: **1 EA.**

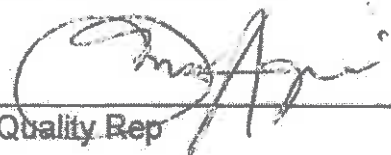
Serial No (S): **006**

Lot/Batch # (when applicable): **N/A**

This is to certify that the material and/or processes used to fabricate the above part number, comply with the specifications, drawings and other requirements of the contract or purchase order indicated.

The required reports and other certificates covering all material in the parts listed above, are on file and available for examination upon request.

Llamas Plastics, Inc.



Quality Rep